

SPECIAL MOISTURE RESISTANCE ELECTRODE FOR WELDING LOW ALLOY AND HIGH TENSILE STRENGTH STEELS.

Alloy Basis

C, Mn, Si



Characteristics :

SME A05 is a low hydrogen electrode with a non-hygroscopic coating offering high tensile strength, ductility, crack resistance and anti-spalling properties under extreme pressure. It is suitable for cast steels containing sulfur and phosphorus. The weld deposits are of X-ray quality providing exceptional toughness and high impact value.

Typical Applications

Ideal for welding high-stress components such as excavator booms, crane jibs, pressure vessels, pipe welding, heavy machinery repairs as well as the fabrication and repair of steel castings, sluice gates and more where minimal distortion and maximum strength are critical.

Mechanical Properties

Tensile Strength: 50 - 58 kg/mm²

Elongation : 22 – 30 %

Welding Current : AC, DCEP

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	60 - 90	100 - 130	140 - 180	180 - 220

Availability:

Standard Size: 5.0, 4.0, 3.15, 2.5 in 350 mm length

Packing: 2 kg.

Procedure

Clean the area to be welded. Use a medium to short arc length. For horizontal fillet welds, use the contact technique. Weld vertical joints from the bottom up with rapid weaving.